

Date: Monday, 6/26/2006 11:17:15 AM
User: Brenda Leonard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 27684
Estimate Number : 11034
P.O. Number : NIA
This Issue : 6/26/2006 S.O. No. : NIA
Prsht Rev. : NC
First Issue : 6/26/2006 Type : MACHINED PARTS
Previous Run : 27301
Written By : See comment below
Checked & Approved By : [Signature]
Comment : Est. A00.11.06 New Issue EC
Est Rev:B Blanks Now Cut on Waterjet 06-06-14 JLM

Drawing Name : STA 84 BRACKET
Part Number : D28031
Drawing Number : D2803 REV B
Project Number : N/A
Drawing Revision : B
Material : NIA
Due Date : 7/3/2006
Qty: 11 Um: 10 Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X10000 6061-T6 Bar .50" x 10.0"



Comment: Qty.: 2.0125 f(s)/Unit Total: 20.1254 f(s)

6061-T6 Bar .50" x 10.0"

Material: 6061-T6 bar 10.00" x 0.50"

Batch: M101262

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per template DT8533

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

SAD 06/06/27 (11)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA102

MP 06/06/30 11

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MP 06/06/30 11

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

EP 06/06/30 x 11

Product:

Serial #:

100
 100

11

1

1

10

6

1

•

4. p. 22

1

4

...

...

1

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/07/11

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date:
User:

Monday, 6/26/2006 11:17:15 AM
Brenda Leonard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 84 BRACKET

Job Number: 27684

Part Number: D28031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr

ml 06/06/30

11

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 06/06/30 7.1.1

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

SAD 06/07/04

11

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *87156*

06/17/05

11

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/07/06

11

Job Completion



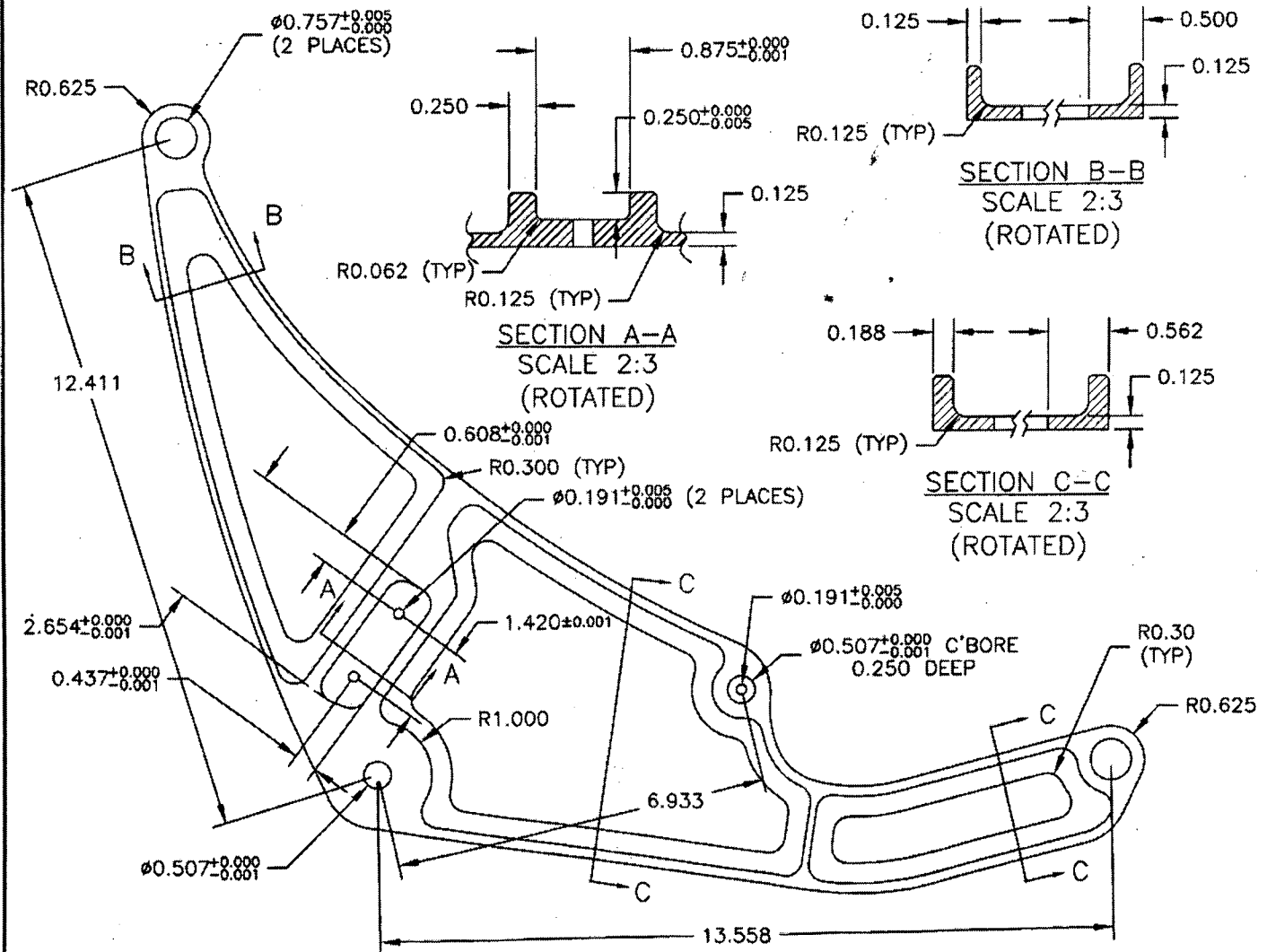
06-07-05

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	SHEET 1 OF 2
				D2803	
DATE	04.11.22			TITLE	SCALE
				STA 84 BRACKET	1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	

RELEASED

05.03.11



**D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

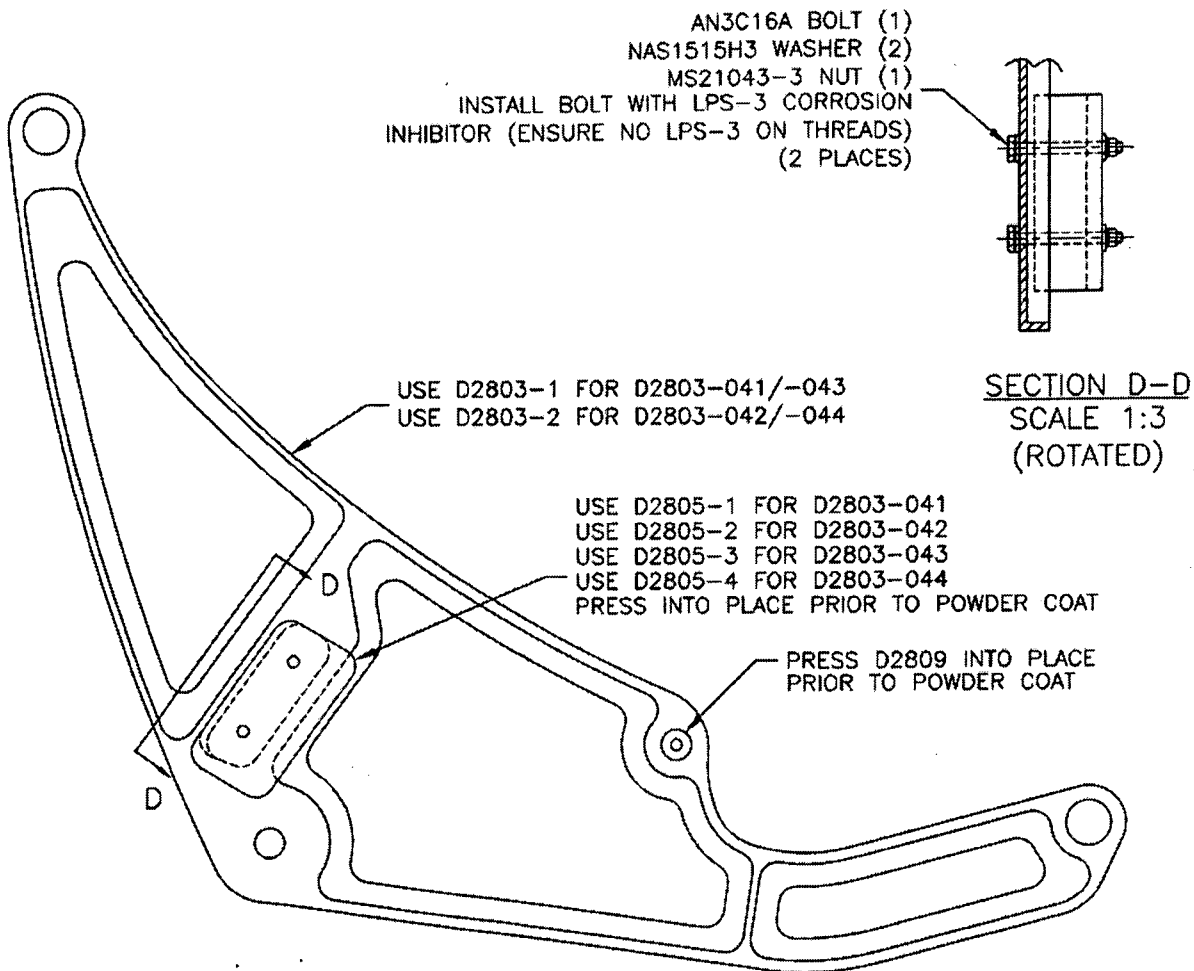

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRF"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3

**RELEASED**05-03-11 **D2803-041/-043 BRACKET ASS'Y (SHOWN)****D2803-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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DART AEROSPACE LTD		Work Order: 27684
Description: Bracket		Part Number: D2803-1
Inspection Dwg: D2803	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.623	+/-0.010					
Ø0.757	+0.005/-0.000	Ø0.758	—			
Ø0.191	+0.005/-0.000	Ø0.191	—			
Ø0.507	+0.000/-0.001	Ø0.507	—			
13.558	+/-0.010	13.558	—			
Ø0.507	+0.000/-0.001	Ø0.507	—			
12.411	+/-0.010	12.411	—			
2.654	+0.000/-0.001	2.654	—			
0.437	+0.000/-0.001	0.437	—			
1.420	+/-0.001	1.419	—			
6.933	+/-0.010	6.933	—			
0.250	+/-0.010	0.247	—			
0.875	+0.000/-0.001	0.875	—			
0.250	+0.000/-0.005	0.247	—			
0.125	+/-0.010	0.128	—			
0.125	+/-0.010	0.125	—			
0.125	+/-0.010	0.130	—			
0.125	+/-0.010	0.128	—			
0.500	+/-0.010	0.503	—			
0.562	+/-0.010	0.565	—			
0.188	+/-0.010	0.189	—			

Measured by: <i>TM</i>	Audited by: <i>EN</i>	Prototype Approval:	N/A
Date: 06/06/29	Date: 06/06/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	<i>[Signature]</i>